

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000316**Date Inspected:** 24-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Material Receiving**Summary of Items Observed:**

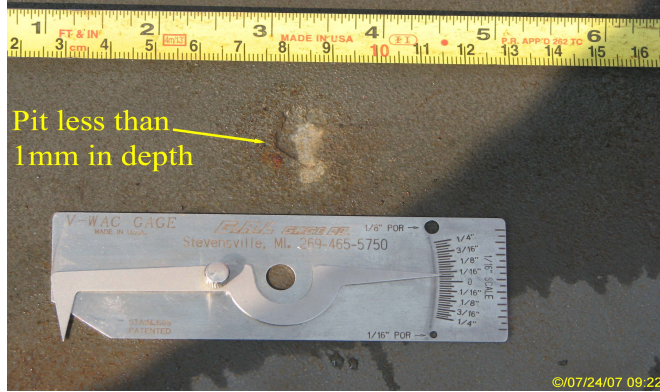
Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger performed material witness inspection for the 55 plates received today. The plates were ASTM A709M-345T2, Z, Z25; A709M-HPS-485WT2, z & Z25 and A572M-gr345-Z25 materials and were accompanied with material test reports some of which had the letter Z or a Z25 after the material type on the MTR. Questions were raised as to why non-fracture critical T2 plates had the requirements of paragraph 12.4.4.1 Optional through-thickness and Low-Sulfur Requirements of the fracture critical section of the code applied to them. The Assigned lot number for these plates is B72-069-07. A review of approximately 27 of the material test reports was completed. There was no Fine grain Practice listed on any of the material test reports and the length of test samples for the elongation is not given on the reports. Review of material test reports will continue tomorrow.

WELDING INSPECTION REPORT

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Small pit in plate 070216Q036, 65 mm thick plate



Summary of Conversations:

No relevant conversations took place on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	McClary, David	QA Reviewer
